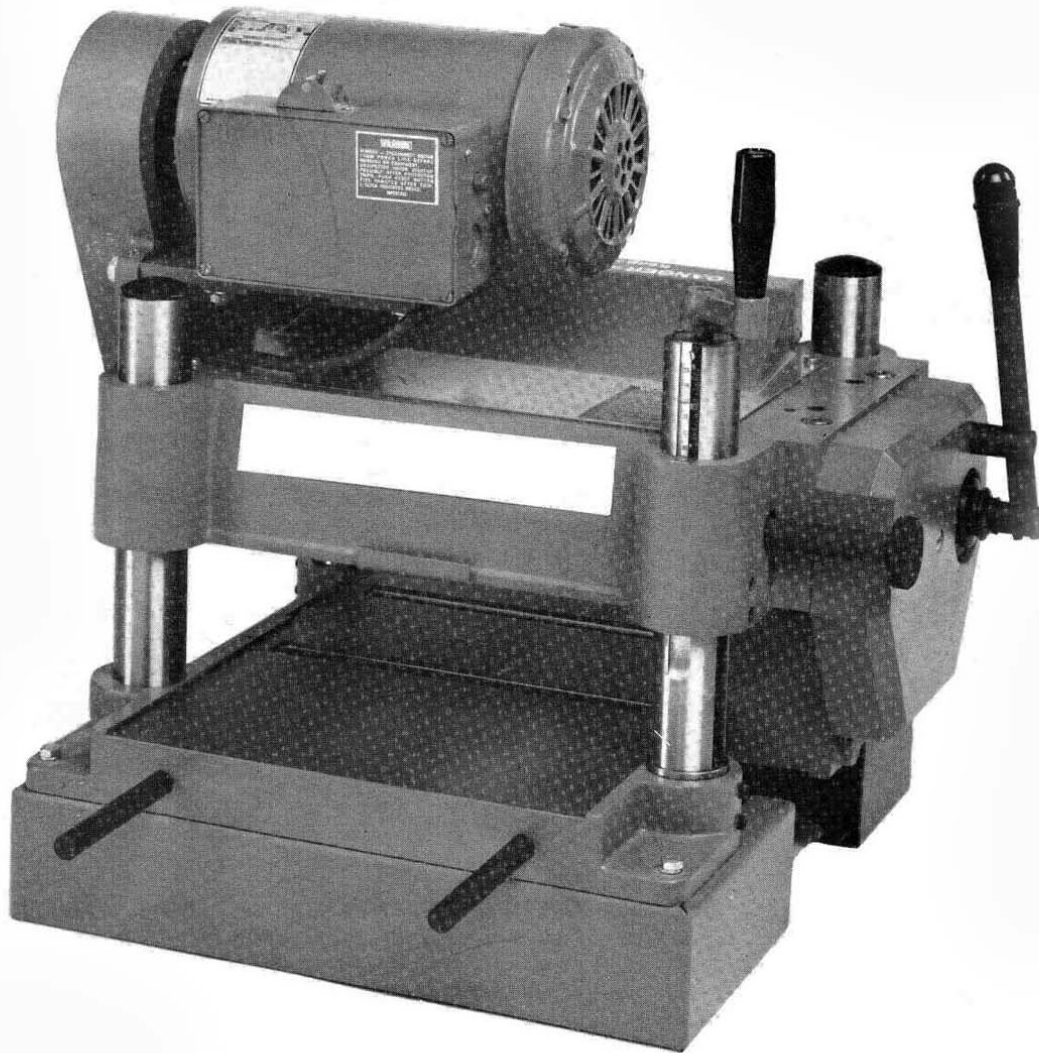


# Model RC-33 13" Planer



INSTRUCTION MANUAL

Dated 12-1-84

Part No. 428-06-651-0003  
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 **DELTA**

**WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN  
SERIOUS PERSONAL INJURY.**

**IMPORTANT**

As with all machinery there are certain hazards involved with operation and use of the machine. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

This machine was designed for certain applications only. Delta Machinery strongly recommends that this machine NOT be modified and/or used for any application other than for which it was designed. If you have any questions relative to its application DO NOT use the machine until you have written Delta Machinery and we have advised you.

DELTA INTERNATIONAL MACHINERY CORP.  
MANAGER OF TECHNICAL SERVICES  
246 ALPHA DRIVE  
PITTSBURGH, PENNSYLVANIA 15238

**SAFETY RULES FOR ALL TOOLS**

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE TOOL.** Learn the tool's application and limitations as well as the specific hazards peculiar to it.
2. **KEEP GUARDS IN PLACE** and in working order.
3. **GROUND ALL TOOLS.** If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter lug must be attached to a known ground. Never remove the third prong.
4. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it "on".
5. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
6. **DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
7. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.
8. **MAKE WORKSHOP CHILDPROOF** - with padlocks, master switches, or by removing starter keys.
9. **DON'T FORCE TOOL.** It will do the job better and be safer at the rate for which it was designed.
10. **USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
11. **WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Nonslip foot wear is recommended. Wear protective hair covering to contain long hair.
12. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operations is dusty. Everyday eyeglasses only have impact resistant lenses; they are NOT safety glasses.
13. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
14. **DON'T OVERREACH.** Keep proper footing and balance at all times.
15. **MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **DISCONNECT TOOLS** before servicing and when changing accessories such as blades, bits, cutters, etc.
17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause hazards.
18. **AVOID ACCIDENTAL STARTING.** Make sure switch is in "OFF" position before plugging in power cord.
19. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
20. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
21. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
22. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.
23. **DRUGS, ALCOHOL, MEDICATION.** Do not operate tool while under the influence of drugs, alcohol or any medication.
24. **MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY** while motor is being mounted, connected or reconnected.

## UNPACKING

Remove the wooden crate from around the machine. Remove four screws (A) Fig. 1, and shipping plates (B). If you purchased the three phase machine, your planer is shipped complete with motor, motor pulley and belts assembled to the machine. The switch is wired to the motor and it is necessary to mount the switch to the side of the planer, as explained later on in this manual.

If you purchased the single phase machine, the belt guard, motor plate and belts are not assembled to the machine. The motor for the single phase machine is shipped in a separate carton and the belt guard, motor plate, motor, motor pulley and belts must be assembled to the planer as explained later on in this manual.

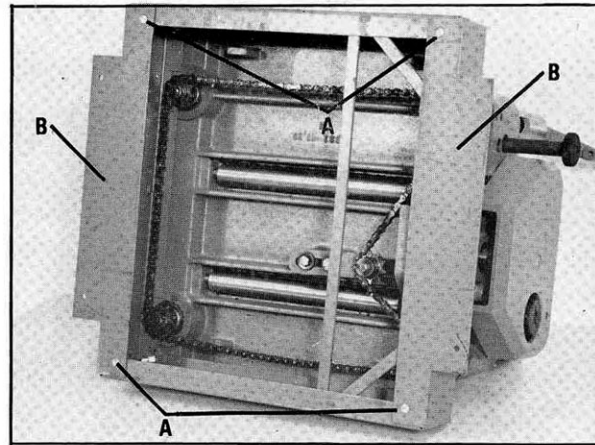


Fig. 1

## CLEANING

Remove the protective coating from the table, bed rolls, feed rolls, cutterhead and loose items packed with the machine, including lifting handles and motor pulley. This coating may be removed with a soft cloth moistened with kerosene (do not use acetone, gasoline, or lacquer thinner for this purpose). **CARE MUST BE TAKEN WHEN CLEANING THE CUTTERHEAD AS THE KNIVES ARE IN THE CUTTERHEAD AND THESE KNIVES ARE VERY SHARP.** After cleaning table, cover table surface with a good quality paste wax.

## ASSEMBLING LIFTING HANDLES

Your machine is supplied with four lifting handles that are to be assembled to the front and rear of the planer table. The two front lifting handles are shown at (A) Fig. 2. To assemble the lifting handles to your planer, proceed as follows.

1. Tilt the machine on its back.
2. Remove retainer (B) Fig. 3, from end of lifting handle (C).
3. Insert groove end of lifting handle (C) through hole in table casting and through hole in boss (D), as shown in Fig. 3.
4. Reassemble retainer (B) Fig. 3, to groove in end of lifting handle.
5. Assemble remaining three lifting handles to planer in the same manner. Fig. 4 illustrates two lifting handles (A) assembled to one end of the machine.

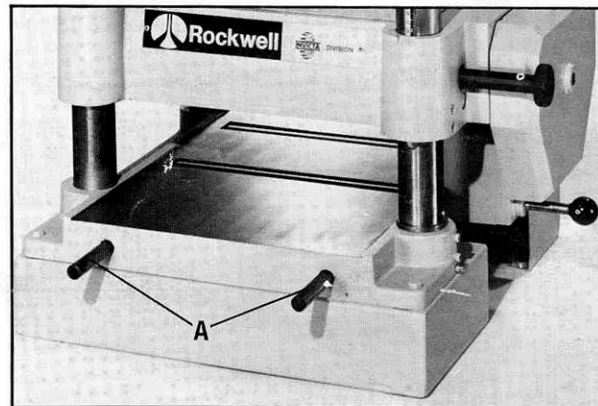


Fig. 2

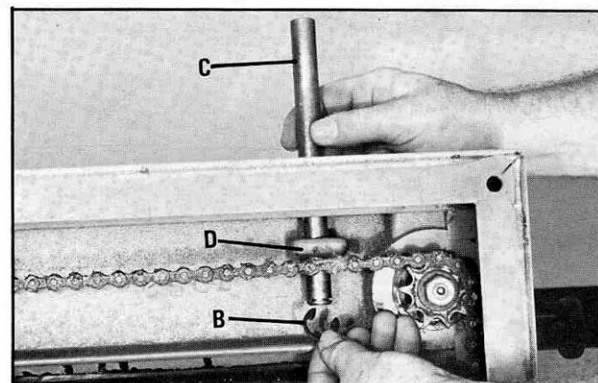


Fig. 3

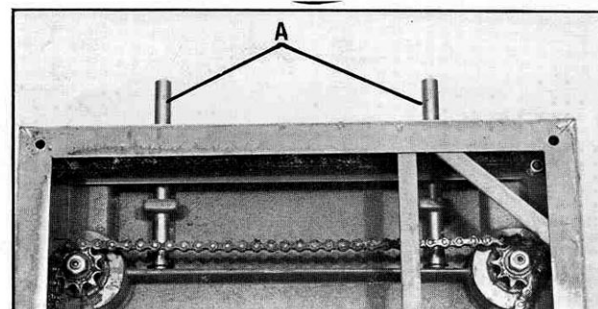


Fig. 4



Fig. 5

## ASSEMBLING ACCESSORY 50-315 STAND

If you purchased the accessory 50-315 Stand for use with your planer, assemble the stand as follows:

1. Assemble the stand as shown in Fig. 5, using the 24 screws and nuts supplied. Only tighten the screws and nuts finger tight at this time.
2. Fig. 6 illustrates the proper relationship of the screws and nuts to the stand. Place the stand on a level surface and tighten the screws and nuts in the following order. First the eight lower tie bar screws and nuts (A), second the eight upper tie bar screws and nuts (B) and third the eight top shelf screws and nuts (C) Fig. 6.

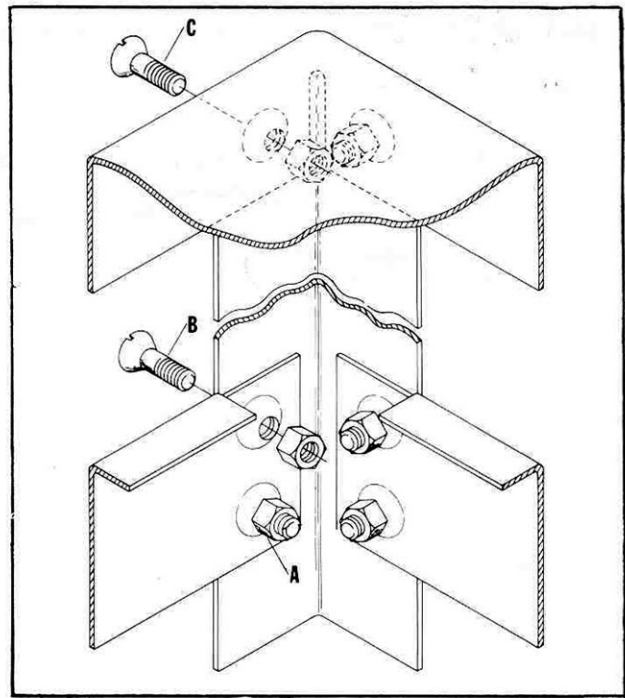


Fig. 6

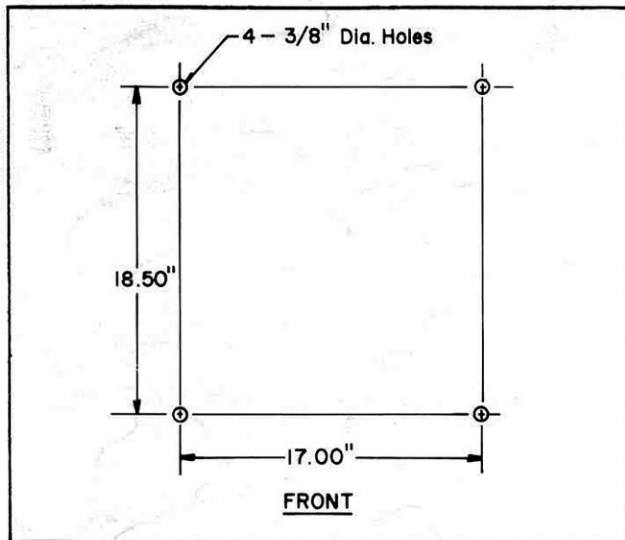


Fig. 7

## ASSEMBLING PLANER TO ACCESSORY 50-315 STAND OR BENCH

If you are assembling the planer to the accessory 50-315 Stand or a bench of suitable height, it will be necessary to drill four holes in either stand or bench. Refer to Fig. 7, for the center to center distance and size of the four holes to be drilled.

When lifting the planer to position it on the stand or bench, the machine must be lifted by the lifting handles. Fig. 8 illustrates the machine being lifted by the lifting handles using a sling.

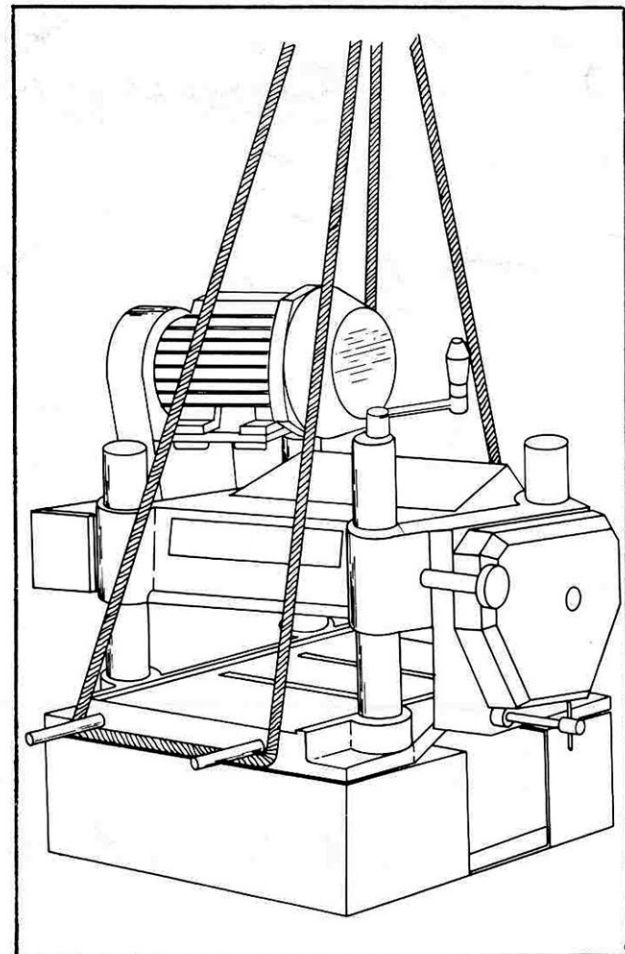


Fig. 8

## ASSEMBLING HEAD RAISING AND LOWERING HANDLE

Using a screw driver (A), assemble the head raising and lowering handle (B) to the handle bracket (C) as shown in Fig. 9.

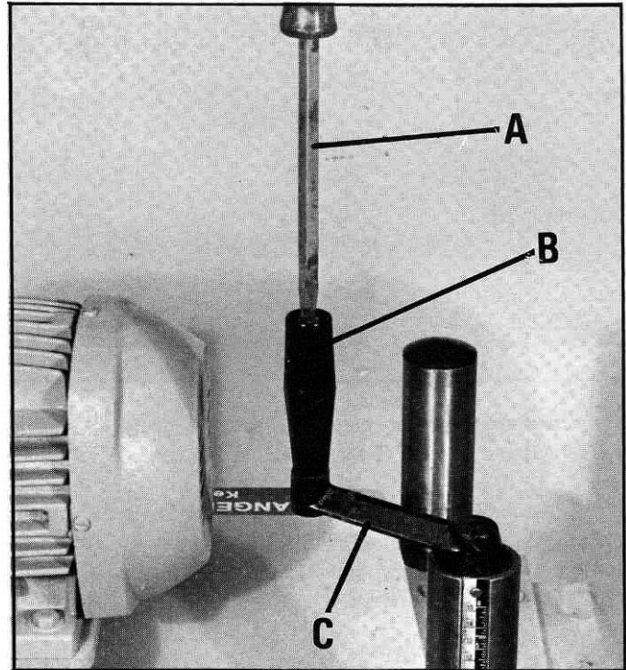


Fig. 9

## ASSEMBLING SWITCH TO THREE PHASE MACHINE

If you purchased the three phase machine, it is necessary to assemble the switch and switch plate assembly (A) to the front left hand side of the planer, as shown in Fig. 10, using the two screws (B).

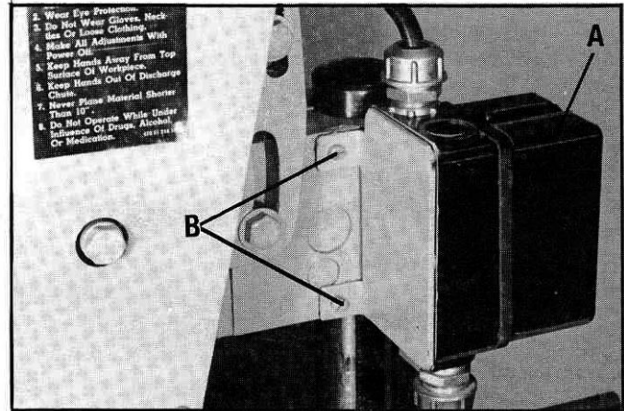


Fig. 10

## ASSEMBLING BELT GUARD, MOTOR PLATE, MOTOR PULLEY, MOTOR AND BELTS TO SINGLE PHASE MACHINE.

1. Remove cover from side of belt guard and assemble belt guard (A) to the side of the planer using screw and washer (B) and long screw (C) and spacer (D), as shown in Fig. 11. The belt guard (A) should be as far to the left as it will travel in slot (E) as shown in Fig. 11, for correct operating position.

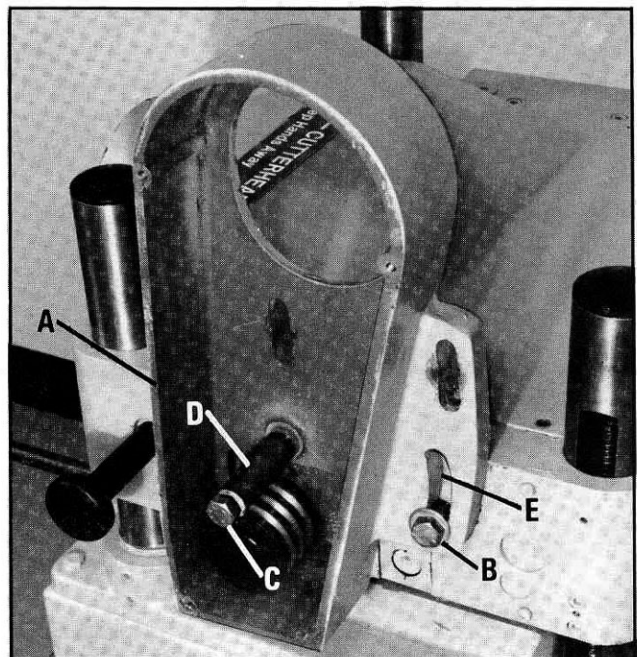


Fig. 11

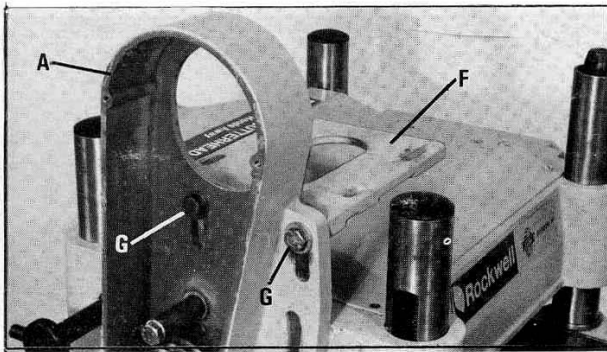


Fig. 12

2. Assemble motor plate (F) to belt guard (A) using two screws and washers (G), as shown in Fig. 12.

3. Assemble motor pulley (H) to motor shaft, as shown in Fig. 13. Make sure key is inserted into keyway of motor shaft and motor pulley and tighten two screws in motor pulley using allen wrench (J).

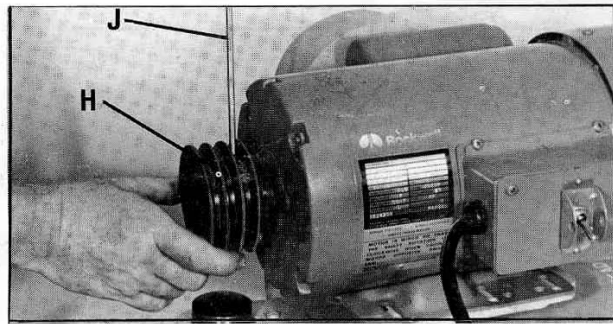


Fig. 13

4. Place motor (K) on motor plate (F), as shown in Fig. 14, with motor pulley through hole in belt guard. Fasten motor (K) to motor plate (F) using the four sets of motor mounting bolts, washer and nuts (L). Do not completely tighten motor mounting nuts and bolts at this point.

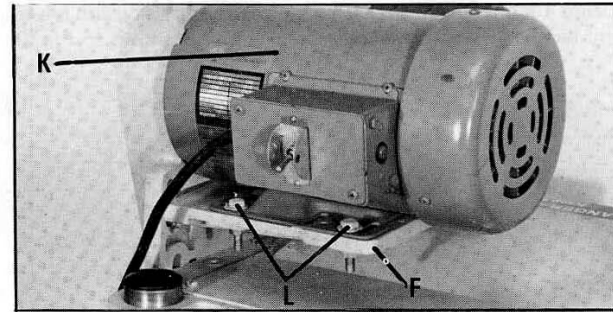


Fig. 14

5. Using a straight edge, align motor pulley (H) to cutterhead pulley (M), as shown in Fig. 15, by sliding motor on motor plate. Then tighten motor mounting hardware.

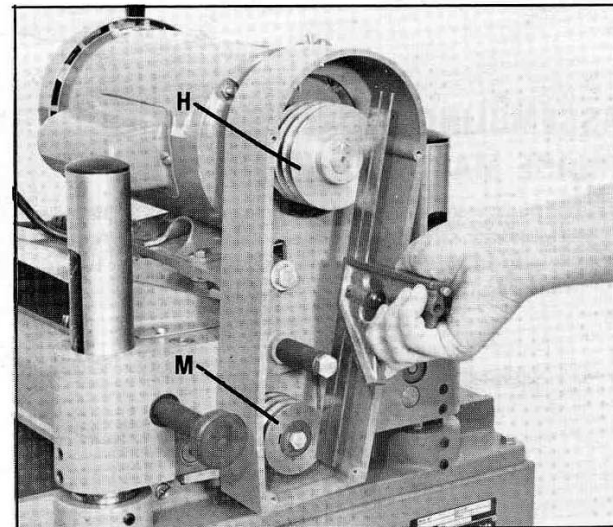


Fig. 15

6. Loosen two screws (G) so that motor plate will move down and assemble the three belts (O) to motor pulley (H) and cutterhead pulley (M), as shown in Fig. 16.

7. Adjust belt tension by referring to the section on **ADJUSTING BELT TENSION** later in this manual.

8. Assemble cover to side of belt guard.

9. The motor cord should be placed through the clamp (P) and the clamp (P) should be fastened to the threaded hole located on the left front top of machine using screw (R), as shown in Fig. 16A.

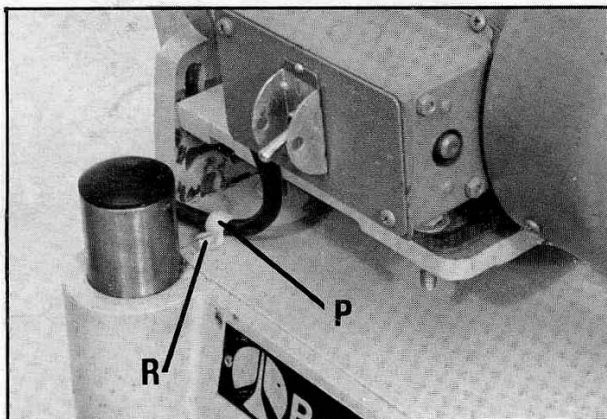


Fig. 16A

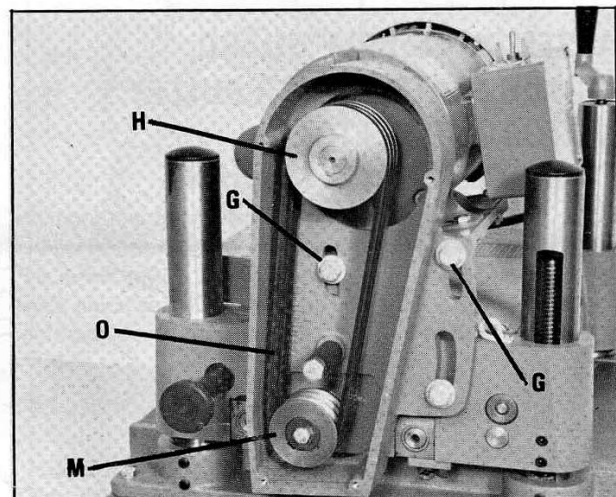


Fig. 16

# ASSEMBLING FEED ROLL SHIFTER MECHANISM

1. Remove screw (A) Fig. 17, and gear box cover (B).

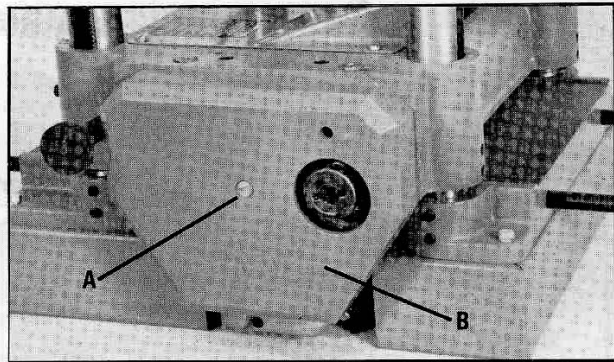


Fig. 17

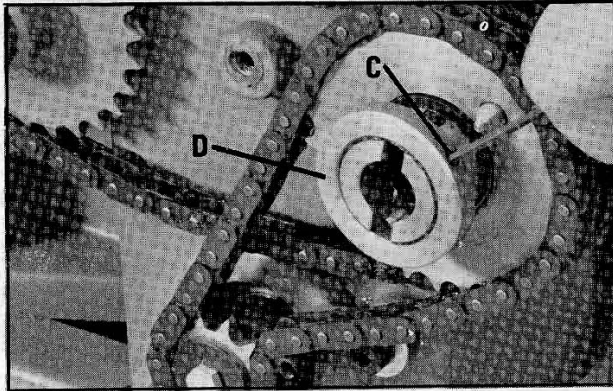


Fig. 18

2. Loosen set screw (C) Fig. 18, and remove collar (D).

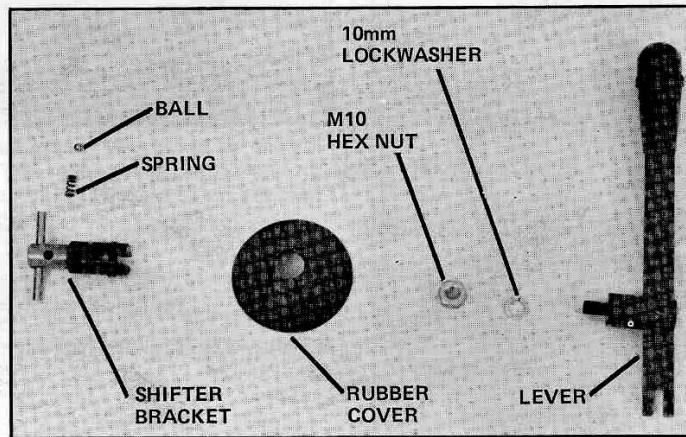


Fig. 19

3. Fig. 19, shows the shifter mechanism components which are shipped unassembled with the planer.

4. Assemble the shifter bracket (E) Fig. 20, spring (F) and ball (G) as shown. NOTE: The spring and ball can be depressed using a small screwdriver blade.

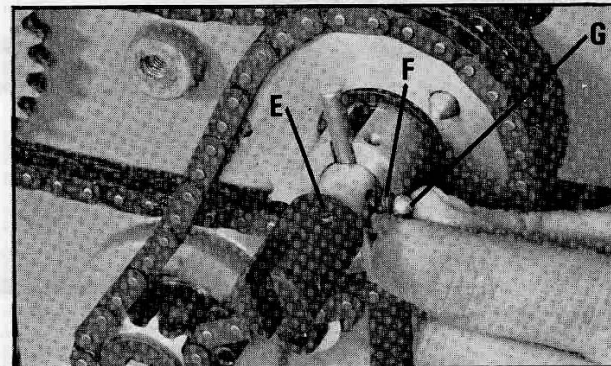


Fig. 20

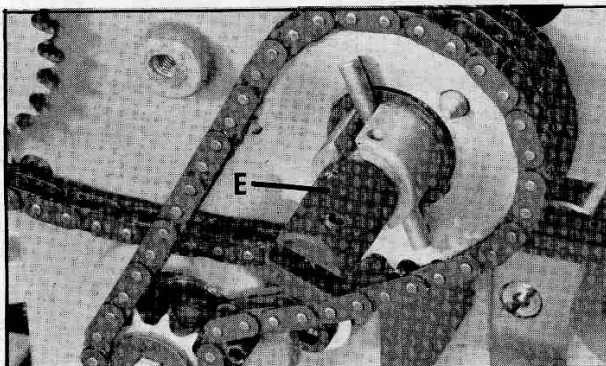


Fig. 21

5. Fig. 21, illustrates the shifter bracket (E) in the assembled position.

6. Reassemble collar (D) Figs. 22 and 23.

7. Tighten set screw (C) Fig. 23, into countersunk hole (H) Fig. 22.

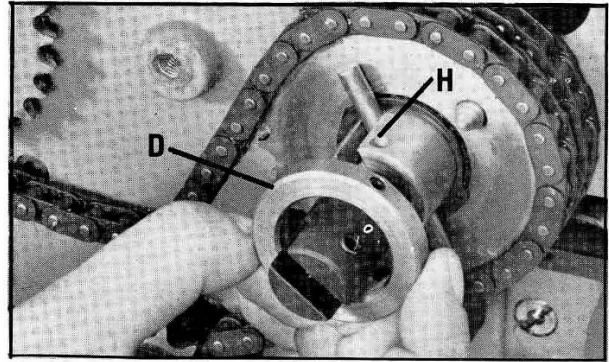


Fig. 22

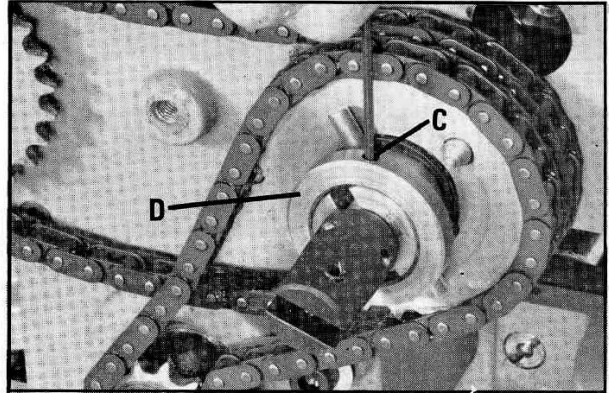


Fig. 23

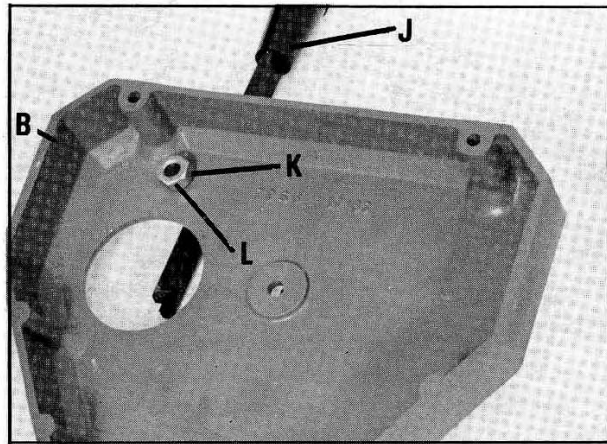


Fig. 24

8. Assemble lever (J) Fig. 24, to gear box cover (B) as shown, using the 10mm lockwasher (K) and M10 hex nut (L) supplied.

9. Assemble rubber cover (M) Fig. 25, over shifter bracket and then assemble gear box cover with lever as shown. Lever should engage shifter bracket.

10. Replace screw (A) Fig. 25, and tighten.

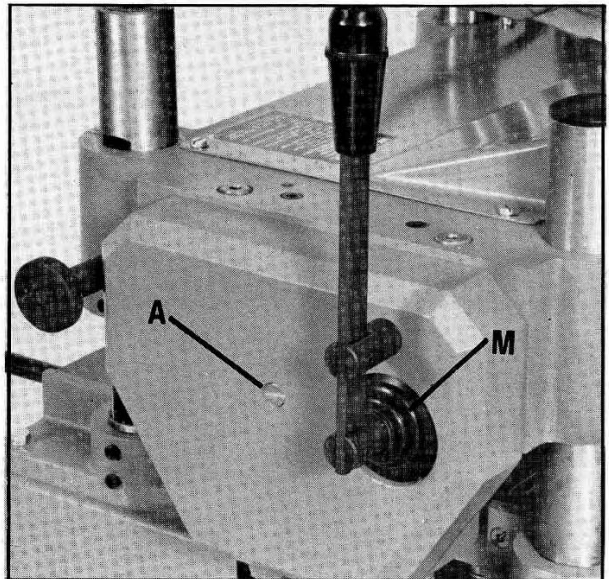


Fig. 25



## ELECTRICAL CONNECTIONS

Before connecting your machine to an electrical power system, make sure the motor rating agrees with the electrical system it is to be connected to.

### SINGLE PHASE MACHINE

The motor supplied with the Single Phase Planer is wired for 230 Volts, Single Phase Operation and is supplied with a power cord equipped with a plug that has two flat, current-carrying prongs in tandem and one round or "U" shaped longer ground prong, as shown in Fig. 26. This is used only with the proper mating 3-conductor grounding type receptacle, as shown in Fig. 26.

When the three-prong plug on your planer is plugged into a grounded, 3-conductor receptacle, as shown in Fig. 26, the long ground prong on the plug contacts first so the machine is properly grounded before electricity reaches it.

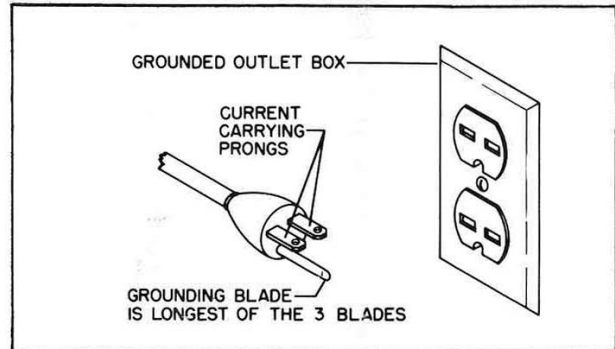


Fig. 26

### THREE PHASE MACHINE

The motor supplied with the Three Phase Planer is wired for 220 Volts, Three Phase Operation. If you desire to operate your planer at 440 Volts, Three Phase Operation refer to the instructions under CHANGING FROM 220 TO 440 VOLTS, THREE PHASE OPERATION.

To connect power to your machine, proceed as follows for either 220 or 440 Volts, Three Phase Operation:

1. Remove two screws, one of which is shown at (A) Fig. 27, and remove switch cover (B).
2. Insert power line (C) Fig. 28, through entrance hole (D) on bottom of switch box, and up in back of starter and overload (E). Connect the three power lines to terminals (F) and the green ground wire to the ground terminal (G) Fig. 28. **IMPORTANT:** If after the machine is in operation, the cutterhead revolves in the wrong rotation, simply interchange any two of the three power lines that are connected to terminals (F) Fig. 28.
3. Replace switch cover.

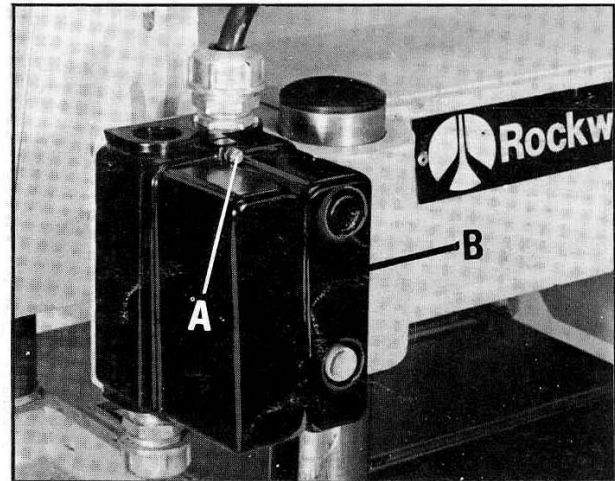


Fig. 27

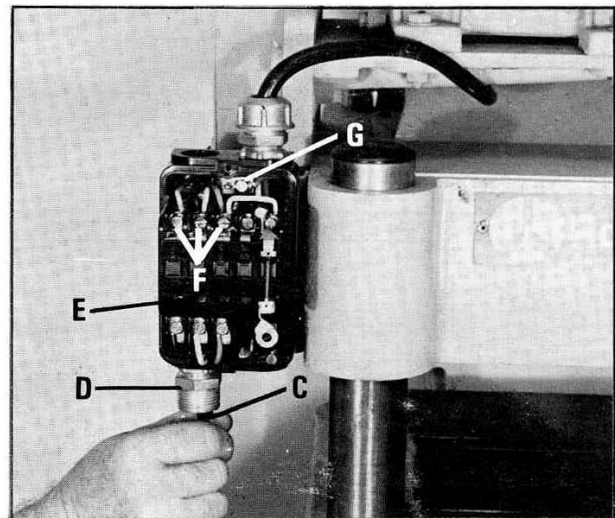


Fig. 28

## CHANGING FROM 220 TO 440 VOLTS, THREE PHASE OPERATION

If you desire to change the voltage on your Three Phase Machine from 220 Volts to 440 Volts, proceed as follows:

1. Disconnect the machine from the power source.
2. Remove two screws, one of which is shown at (A) Fig. 29, and remove switch cover (B).

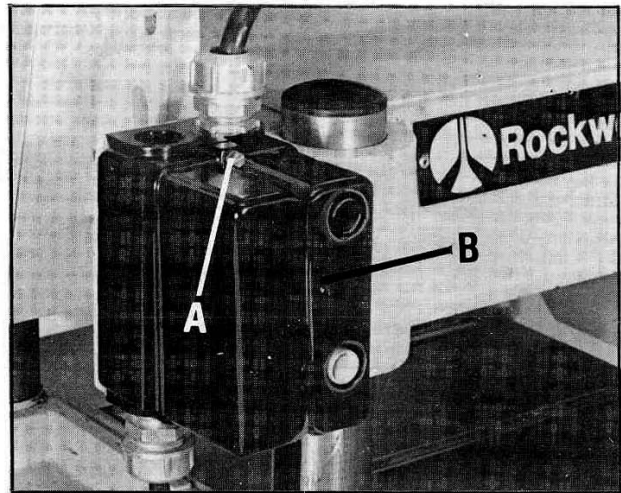


Fig. 29

3. Loosen screw (C) Fig. 30, and pull out starter and overload block (D).

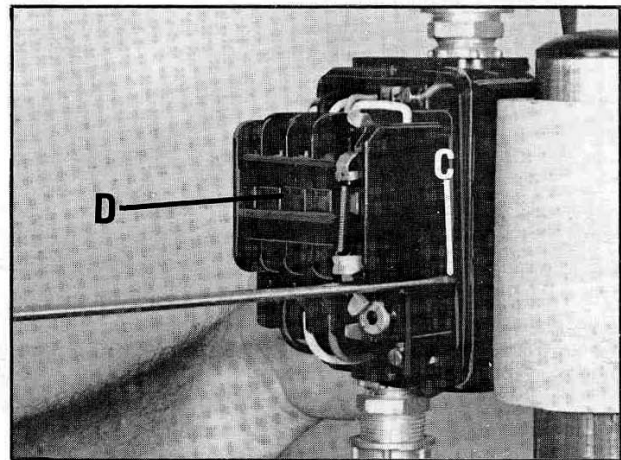


Fig. 30

4. Fig. 31, illustrates the starter and overload block (D) removed from the switch box. Remove two screws (E) Fig. 31 and hold plate (F) so it will not spring out. Carefully remove plate (F) Fig. 31.

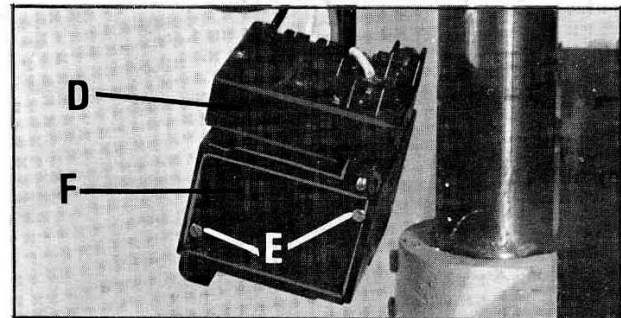


Fig. 31

5. Remove yoke (G) Fig. 32.

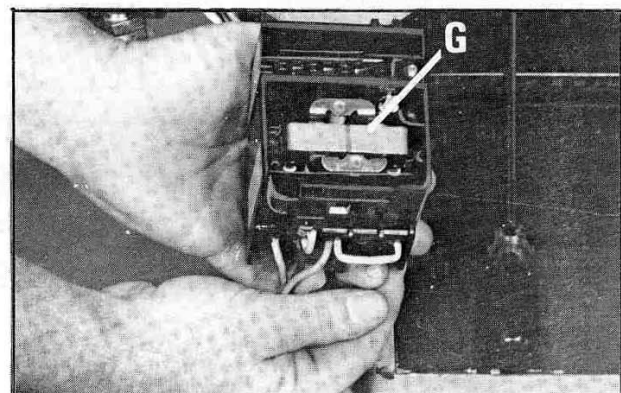


Fig. 32

6. Remove plate (H) and two springs, one of which is shown at (J) Fig. 33.

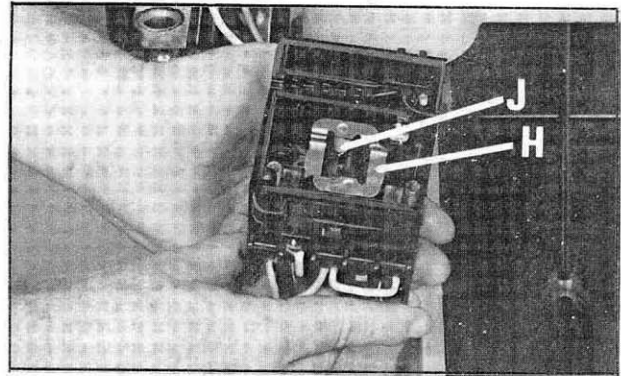


Fig. 33

7. Pull out, disconnect leads, and remove 220 Volt coil (K) Fig. 34.

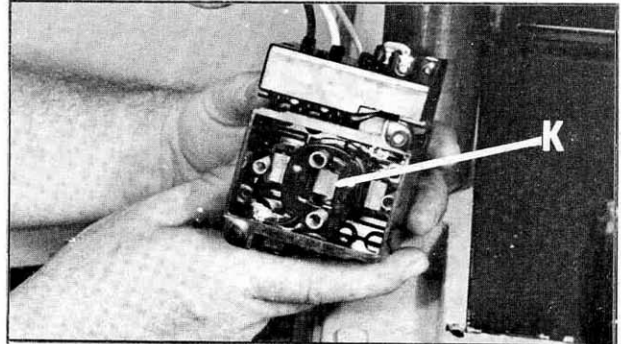


Fig. 34

8. Replace with 440 Volt coil (available from Rockwell as part no. 438-01-003-0434), and reassemble in the reverse order.

9. For 440 Volt operation, the amp setting dial (L) Fig. 35, should be set at 5.0. For 220 Volt operation, the amp setting dial (L) should be set at 9.0.

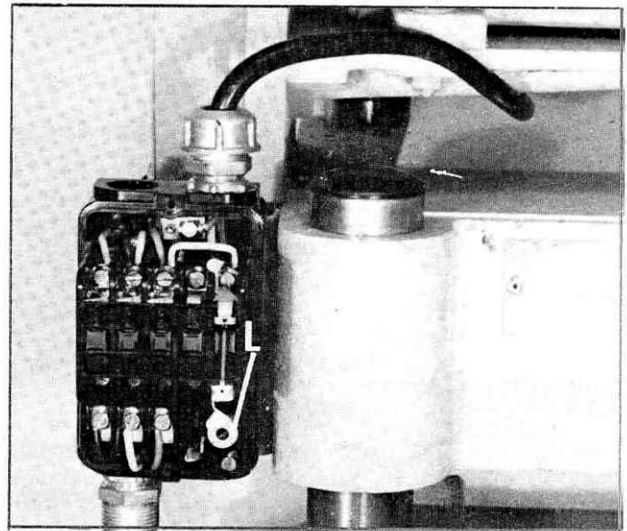


Fig. 35

10. Remove motor junction box cover to expose motor wires and reconnect motor wires for 440 Volt operation. Fig. 36 illustrates motor wire connections for 220 Volts and 440 Volts.

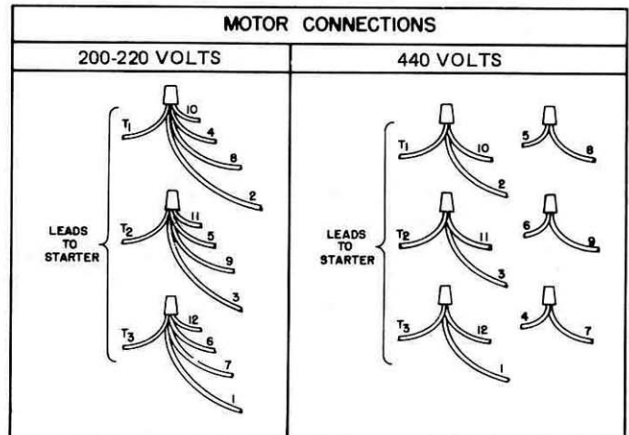


Fig. 36

## OPERATING CONTROLS

### SWITCH

The ON-OFF switch for Single Phase machines is located on the front portion of the motor, as shown at (A) Fig. 37.

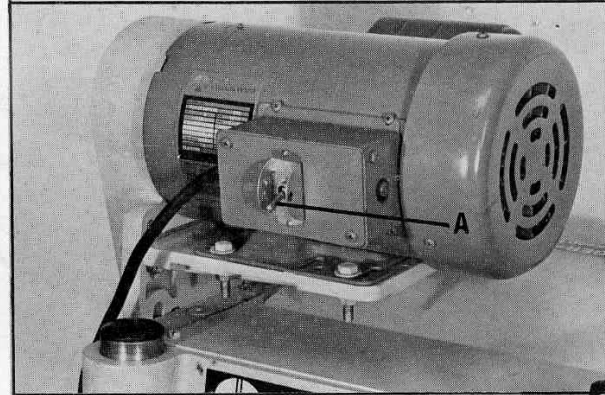


Fig. 37

The ON-OFF switch for Three Phase machines is located on the switch box, as shown at (B) Fig. 38.

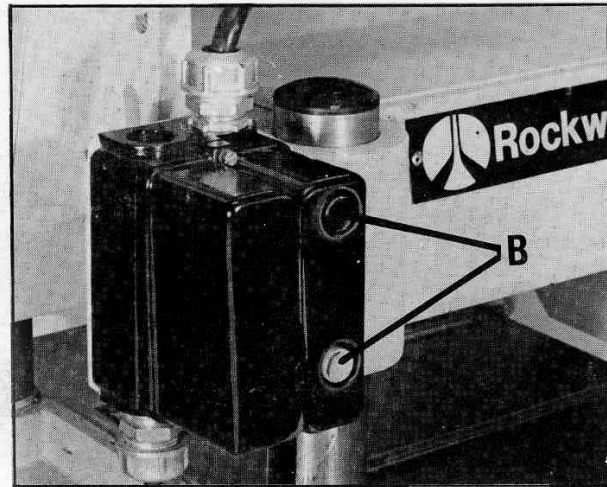


Fig. 38

### OVERLOAD PROTECTION

Your planer is provided with overload protection which will shut off the motor if the planer is overloaded or if line voltage falls below safe levels. If the motor shuts off due to overloading or low voltage, proceed as follows for Single and Three Phase machines: On Single Phase machines, shut off switch (A) Fig. 39, let the motor cool for approximately five minutes and push the reset button (B), which will reset the overload device. The motor can then be turned on again in the usual manner.

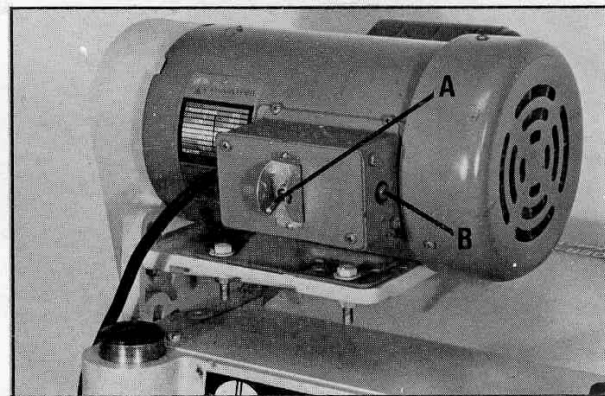


Fig. 39

On Three Phase machines, let the motor cool for approximately five minutes. The overload block supplied with this planer will automatically reset itself and the machine can be started again by pushing the start button.

If the machine, either single or three phase, continually shuts off due to overloading, the cause of overloading must be corrected. If this happens, it is recommended you obtain advice from a qualified electrician.

## DEPTH OF CUT ADJUSTMENT

The depth of cut on your planer is controlled by raising or lowering the head assembly (A) Fig. 40, which contains the cutterhead and feed rolls. The head assembly (A) raises and lowers on four precision ground steel columns. To adjust for depth of cut simply loosen the two head assembly lock knobs (C) and turn the elevating handle (D) Fig. 40. After the desired depth of cut is obtained, lock the two head assembly lock knobs (C) Fig. 40. A combination inch/metric scale (B) Fig. 40, is conveniently located on the right front column for easy reading.

The maximum depth of cut on full width planing with the 3 horsepower, Three Phase motor is 3/16" (4.763 mm).

The maximum depth of cut on full width planing with a 2 Horsepower, Single Phase motor is 1/8" (3.175 mm). A limiter (A) Fig. 41, is provided on single phase machines to limit the depth of cut on full width planing from 3/16" to 1/8".

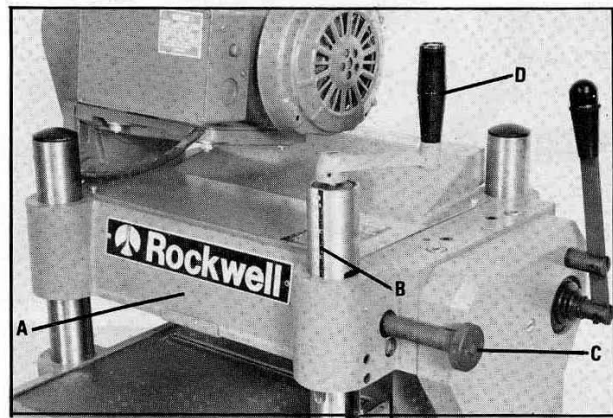


Fig. 40

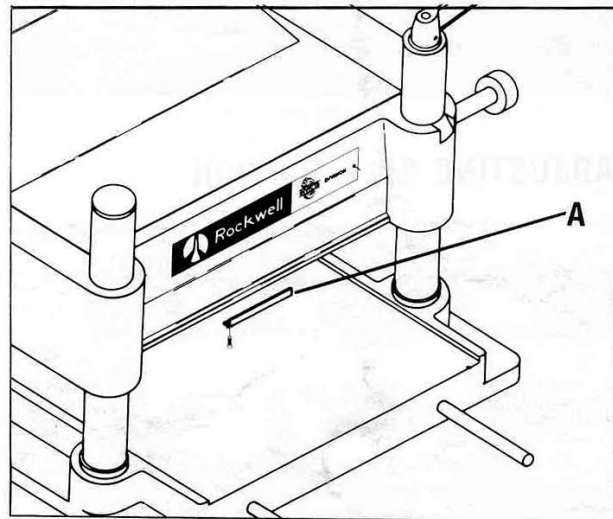


Fig. 41

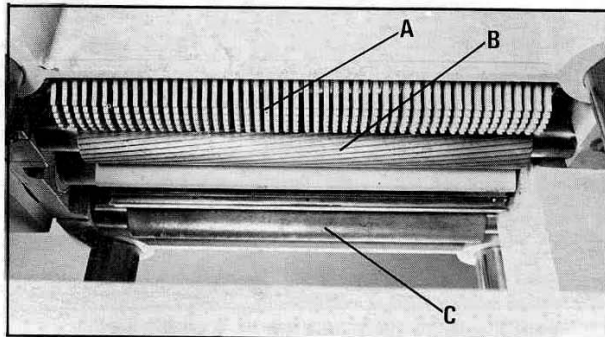


Fig. 42

## ANTI-KICKBACK FINGERS

Anti-kickback fingers (A) Fig. 42, are provided on your planer to prevent kickback. These fingers operate by gravity and it is necessary to inspect them occasionally to make sure they are free of gum and pitch so that they move independently and operate correctly.

## FEED ROLL SPEED CONTROL

Your machine is equipped with a spiral, serrated infeed roll (B) and a solid steel outfeed roll (C) Fig. 42.

When the feed rolls are engaged, they turn and feed the stock. The feed rolls slow automatically when the machine is under heavy load for best planing under all conditions. The feed rolls are driven by a chain and sprocket drive (D) Fig. 43, which takes power directly from the cutterhead through the oil bath gear box (E).

To engage the feed rolls, pull out lever (F) Fig. 44. To disengage the feed rolls push in lever (F).

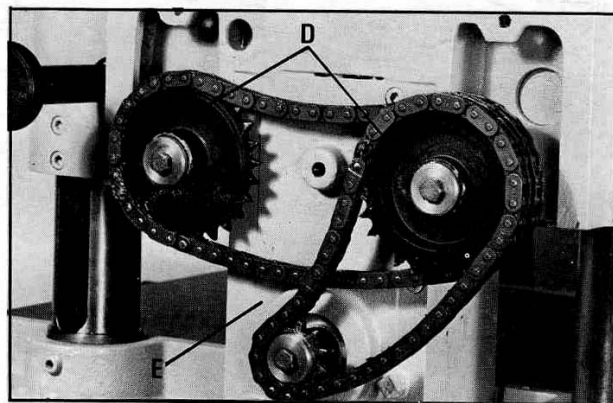


Fig. 43

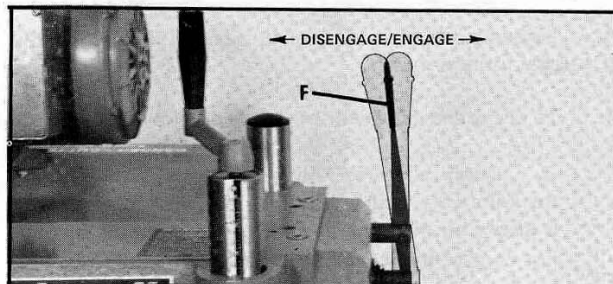


Fig. 44

## ADJUSTMENTS

Although your planer was carefully adjusted at the factory, it should be checked before being put into operation. Any inaccuracies due to rough handling in transit can easily be corrected by following these directions.

In order to check the adjustments you will need a straight edge, feeler gage and a homemade gage block made of hardwood. This gage block can be made by following the dimensions shown in Fig. 45.

**WHEN CHECKING ADJUSTMENTS, ALWAYS MAKE SURE THE PLANER IS DISCONNECTED FROM THE POWER SOURCE.**

## ADJUSTING BELT TENSION

To adjust the belt tension on your machine, proceed as follows:

1. Disconnect machine from the power source.
2. Remove belt and pulley cover from the machine.
3. Place a 2 x 4 (A) Fig. 46, underneath the motor plate, as shown.
4. Loosen two bolts (B) Fig. 46, and pry up on the motor plate until correct belt tension is obtained. Correct tension is obtained when there is approximately 1/4" deflection in the center span of the belts using light finger pressure. Then tighten two bolts (B) Fig. 46, and replace side cover.

## CHECKING, ADJUSTING AND REPLACING KNIVES

When checking, adjusting or replacing the cutterhead knives, proceed as follows:

1. Disconnect the machine from the power source.
2. Remove four screws, three of which are shown at (A) Fig. 47, and remove top cover (B).
3. Loosen two screws (C) Fig. 48, and tilt motor assembly (D) to the front as shown.
4. To check and adjust knives, proceed as follows:

A. Check all three knives for proper setting using the knife gage as shown in Fig. 49. When the gage (A) is placed on the cutterhead as shown, the knife should just contact the bottom of both set screws (B) Fig. 49.

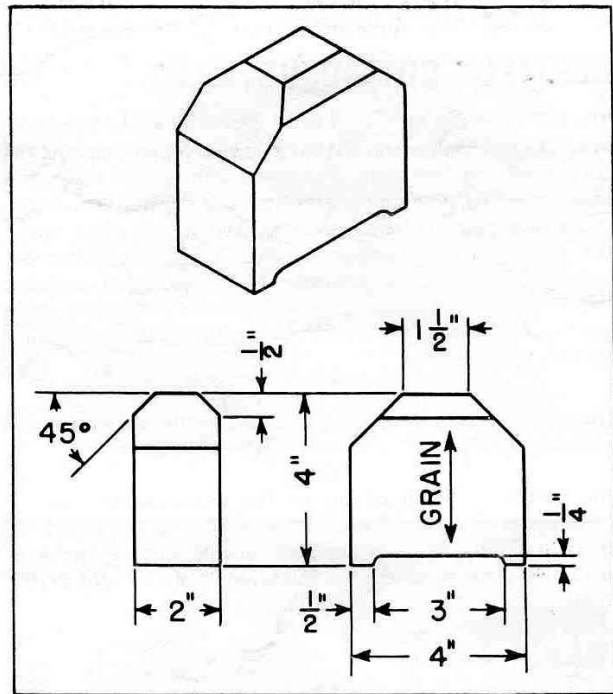


Fig. 45

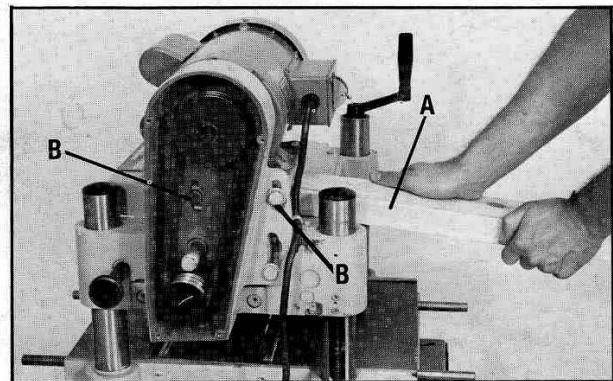


Fig. 46

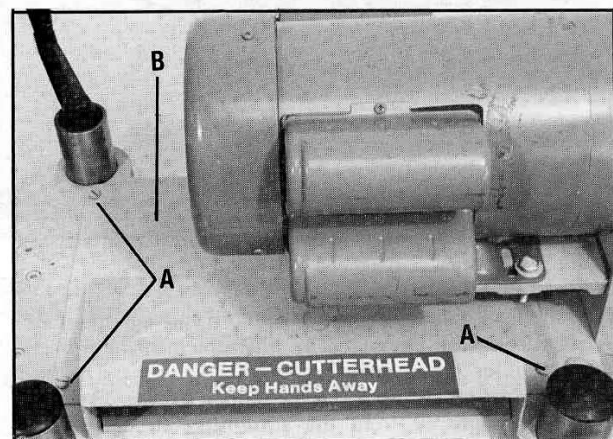


Fig. 47

B. If any of the knives require an adjustment, slightly loosen the knife locking bar of each of the three knives by turning the locking screws (D) Fig. 49, into the locking bar just enough to relieve stress in the cutterhead but not disturb the setting of the three knives.

C. To adjust the knife that must be reset, loosen all four locking screws (D) Fig. 49, by turning them into the locking bar. As the knife locking bar becomes loose, lifter springs under the knife will raise the knife until it contacts the bottom of both set screws (B) of the gage. Then snug up the knife locking bar by lightly backing out the four locking screws (D) against the knife slot. **IMPORTANT: AT THIS TIME, ONLY TIGHTEN THE KNIFE INTO THE SLOT ENOUGH TO HOLD IT IN POSITION.**

D. If additional knives must be reset, repeat Step C.

E. After all three knives are set with screws just snug, back out and tighten the four locking screws (D) Fig. 49, against the slot, starting with the end screws first, then the center screws until the knife is securely held in the cutterhead. Tighten the remaining two knives in the same manner.

5. If the knives are removed for sharpening, care must be exercised in replacing and resetting them, as follows:

A. To remove each knife, loosen the knife locking bar, by turning the four locking screws (D) Fig. 49, into the knife locking bar and remove the locking bar, knife and springs located under the knife.

B. Remove the remaining two knives in the same manner.

C. Thoroughly clean the knife slots, knife bars, springs and screws. Check the screws. If the threads appear worn or stripped or if the heads are becoming rounded replace them.

D. Inspect the cutting edge of the knives for nicks or wire edge. Hone the knives slightly using a stone or if the knives are to be sharpened, maintain a cutting angle of 35 degrees.

E. Insert springs, knives and knife locking bars into all three slots in the cutterhead. Back out locking screws (D) Fig. 49, just enough to hold all three knives in the cutterhead.

F. Adjust all three knives as explained in Step 4, above.

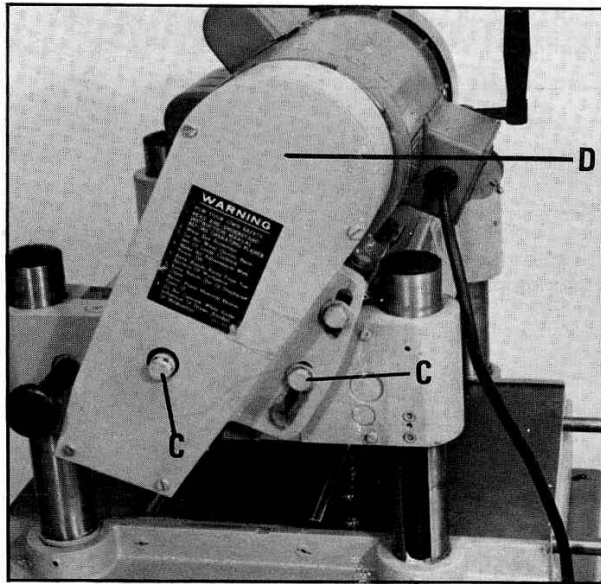


Fig. 48

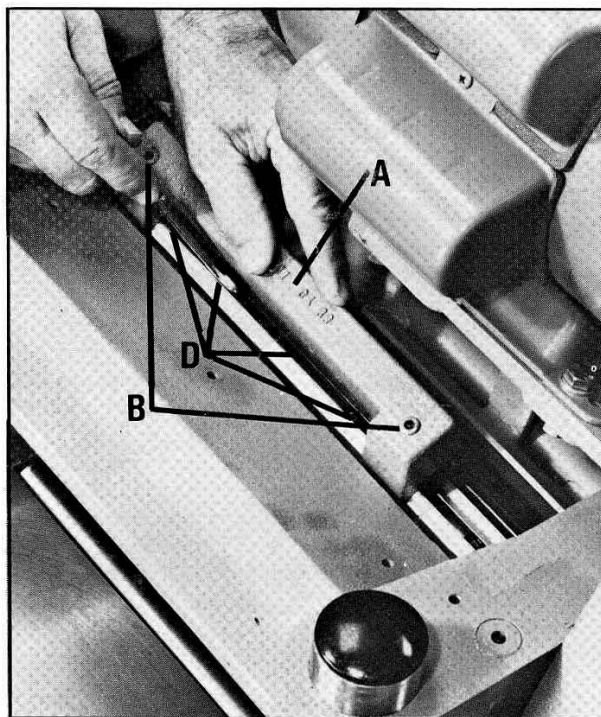


Fig. 49

## ADJUSTING FEED ROLL SPRING TENSION

The infeed roll (A) and outfeed roll (B) Fig. 50, are those parts of your planer that feed the stock while it is being planed. The feed rolls (A) and (B) are under spring tension and this tension must be sufficient to feed the stock uniformly through the planer without slipping but should not be too tight that it causes damage to the board. The tension should be equal at both ends of each roll.

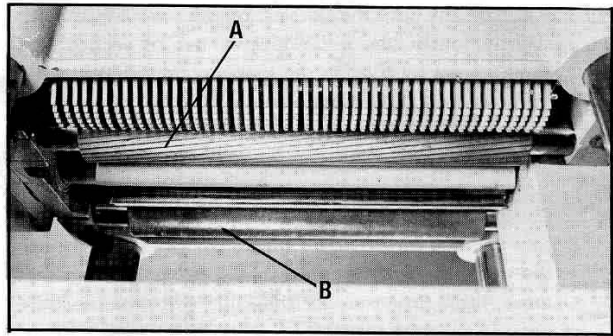


Fig. 50

To adjust the spring tension of the infeed roll, turn screw (C) Fig. 51, and also the screw on the opposite end of the roll.

To adjust spring tension of the outfeed roll, turn screw (D) Fig. 51, and also the screw on the opposite end of the planer.

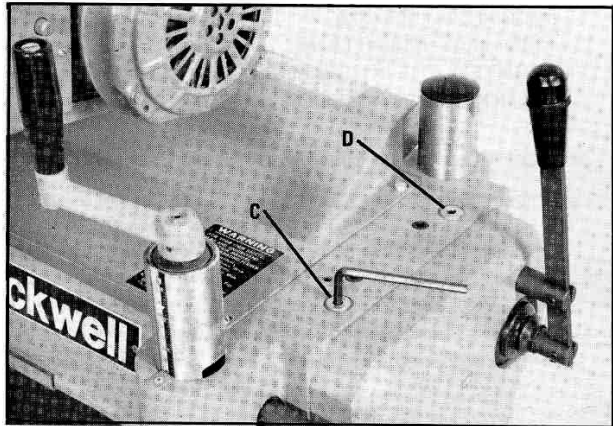


Fig. 51

## ADJUSTING HEIGHT OF OUTFEED ROLL

The outfeed roll is adjusted at the factory to be set .040" below the cutting circle. To check and adjust the outfeed roll, proceed as follows:

1. Disconnect machine from the power source.
2. Make sure the knives are adjusted properly as explained under CHECKING, ADJUSTING AND REPLACING KNIVES.
3. Place the gage block (A) Fig. 52, on the table directly underneath the cutterhead, as shown. Using a .040" feeler gage (B) Fig. 52, placed on top of the gage block, raise or lower the head until the knife (C) just touches the feeler gage when the knife is at its lowest point. Do not move the head any further until the outfeed roll is adjusted.

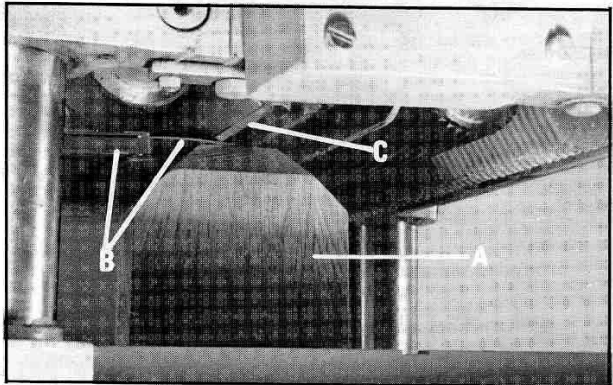


Fig. 52

4. Move the gage block (A) Fig. 53, under one end of the outfeed roll (B) as shown. The bottom of the outfeed roll (B) should just touch the top of the gage block (A). If an adjustment to the outfeed roll is necessary, loosen locknut (E) and turn screw (F) until the feed roll just touches the gage block. Then tighten locknut (E) Fig. 53.

5. Check and adjust opposite end of outfeed roll in the same manner.

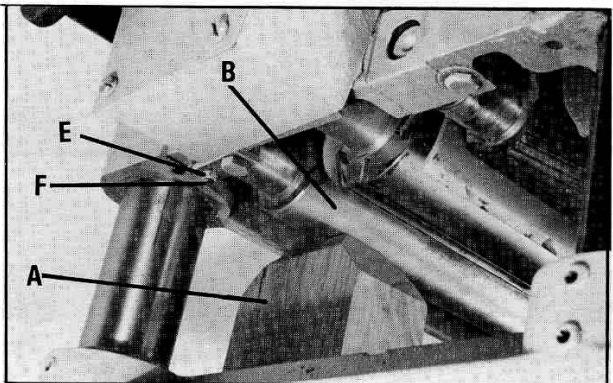


Fig. 53



## ADJUSTING CHIPBREAKER

The chipbreaker is located on top of the planer and extends down around the front of the cutterhead. The chipbreaker raises as stock is fed through and "breaks or curls" the chips the same as a plane iron cap on a hand plane. The bottom of the chipbreaker must be parallel to the knives and set .040" below the cutting circle. To check and adjust the chipbreaker, proceed as follows:

1. Disconnect machine from the power source.
2. Make certain the knives are adjusted properly as previously explained under CHECKING, ADJUSTING AND REPLACING KNIVES.
3. Place the gage block (A) Fig. 54, on the table directly underneath the cutterhead, as shown. Using a .040" feeler gage (B) Fig. 54, placed on top of the gage block, raise or lower the head until the knife (C) just touches the feeler gage when the knife is at its lowest point. Do not move the head any further until the chipbreaker is checked and adjusted if necessary.
4. Move the gage block (A) underneath the chipbreaker (D) as shown in Fig. 55. The bottom of the chipbreaker should just touch the top of the gage block. Check opposite end of chipbreaker in the same manner.
5. If an adjustment to the chipbreaker is necessary, loosen nuts (F) Fig. 56, and turn screws (E) until bottom of chipbreaker just touches gage block. Then tighten nuts (F).

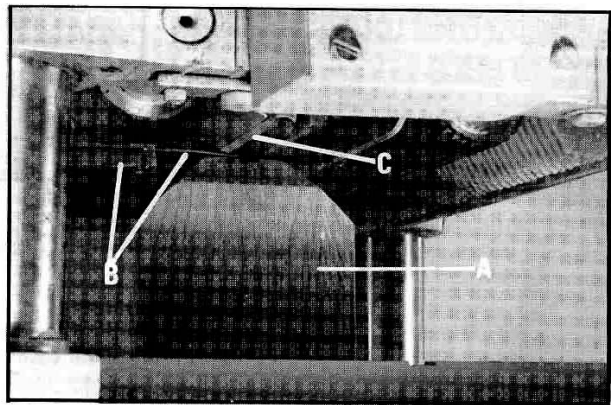


Fig. 54

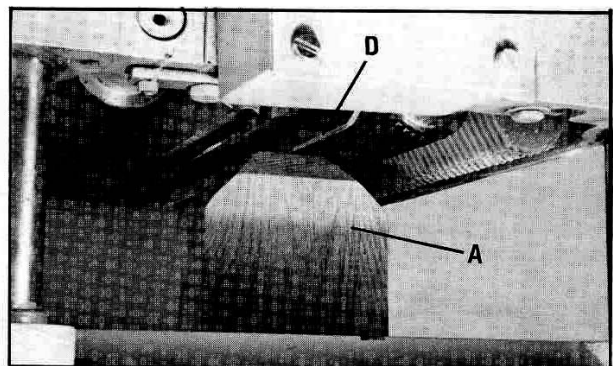


Fig. 55

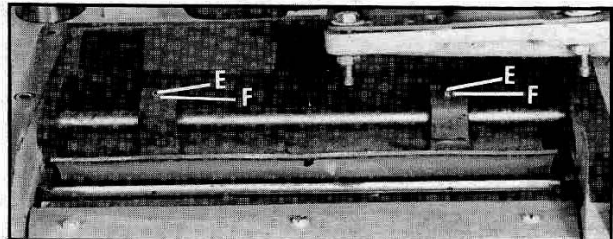


Fig. 56

## ADJUSTING TABLE ROLLS

Your planer is supplied with two table rolls (A) Fig. 57, which aid in feeding the stock by reducing friction and turn as the stock is fed through the planer. It is not possible to give exact dimensions on the proper height setting of the table rolls because each type of wood behaves differently. As a general rule, however, when planing rough stock the table rolls should be set HIGH and when planing smooth stock the table rolls should be set LOW.

The table rolls on your planer are set for average planing and are parallel to the table surface. If you desire to adjust the table rolls higher or lower, proceed as follows:

1. Disconnect machine from the power source.
2. Lay a straight edge (B) Fig. 58, across both rolls and with a feeler gage (C) as shown, adjust height of table rolls by loosening set screws (D) Fig. 57, and turn screws (E) to raise or lower table rolls (A). Table rolls must also be adjusted on the opposite end of table in the same manner. The table rolls must always be set parallel to the table.

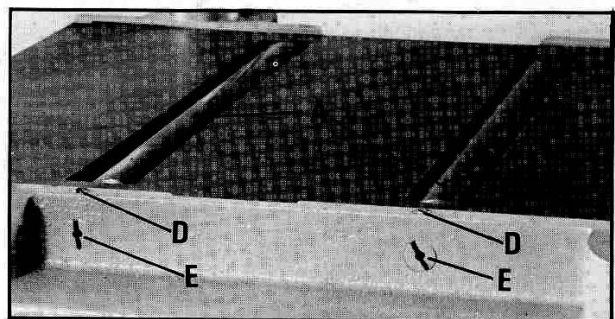


Fig. 57

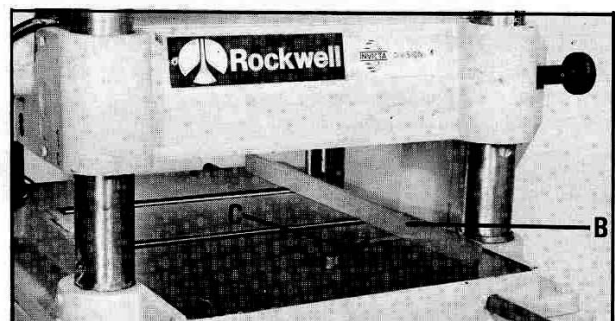


Fig. 58

## ADJUSTING CUTTINGHEAD PARALLEL TO TABLE

The cuttinghead is set parallel to the table at the factory and no further adjustment should be necessary. If your machine is planing a taper first check to see if the knives are set properly in the cutterhead. Then check to see if the table is set parallel to the cuttinghead as follows:

1. Disconnect machine from the power source.
2. Place gage block (A) Fig. 59, on table directly under front edge of head casting (B) as shown. Lower head casting until front edge of head casting (B) just touches gage block.

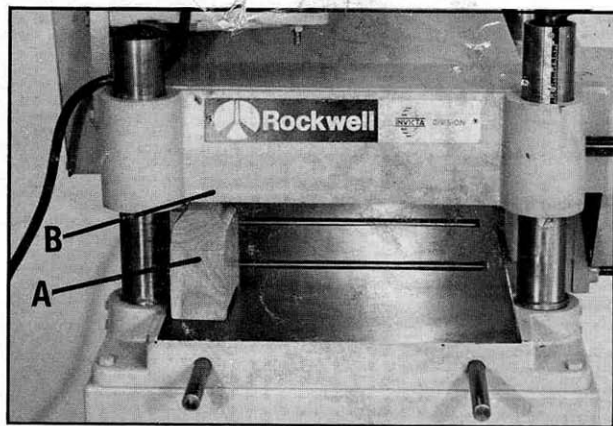


Fig. 59

3. Move gage block (A) Fig. 60, to opposite end of table, as shown. Distance from table to edge of head casting should be the same.
4. Repeat STEPS 2 and 3 on outfeed end of table.

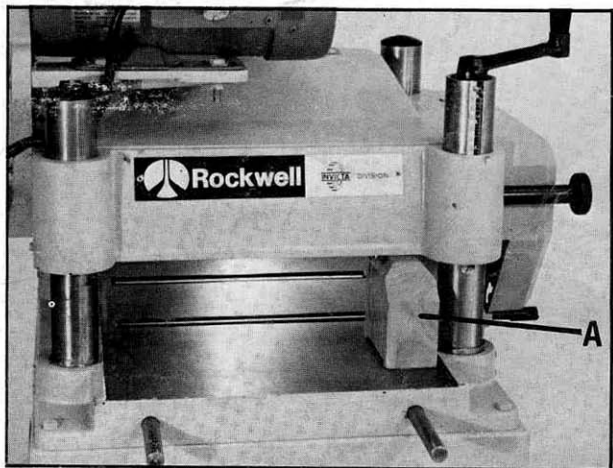


Fig. 60

5. If head casting is not parallel to table, tilt planer on its side as shown in Fig. 61. Remove bolt (C) and loosen bolt (D) Fig. 61, which will allow you to move the idler sprocket assembly (E) far enough to release tension on chain as shown in Fig. 62. Remove chain from sprocket on end of headcasting that must be adjusted. In this case chain has been removed from sprocket (F).

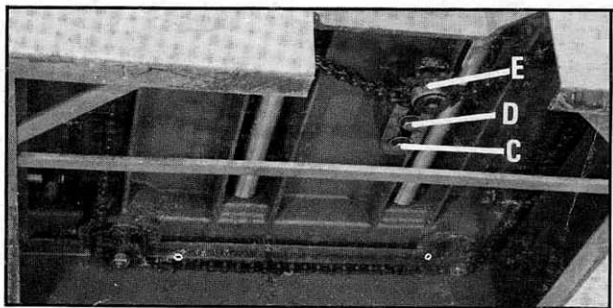


Fig. 61

6. Turn sprocket (F) Fig. 62, by hand to bring that corner into adjustment with other three corners. **IMPORTANT: THIS ADJUSTMENT IS VERY SENSITIVE AND IT SHOULD NOT BE NECESSARY TO TURN THE SPROCKET MORE THAN ONE OR TWO TEETH.** Turning sprocket (F) clockwise will decrease the distance between the table and headcasting. Counter-clockwise will increase the distance.

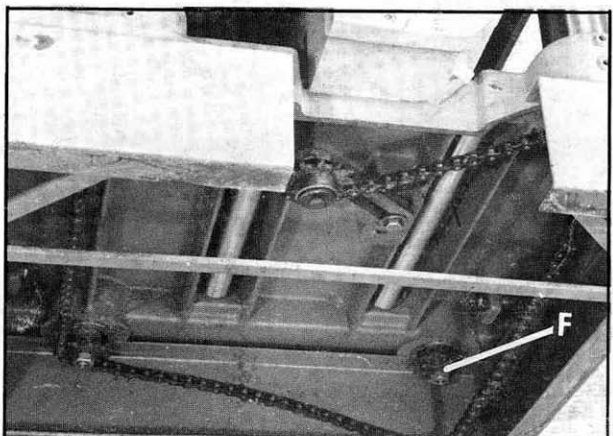


Fig. 62

7. Replace chain being careful not to disturb the position of the sprockets and replace idler sprocket assembly (E) Fig. 61.